

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009597**Date Inspected:** 15-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 008 located on Counter Weight CW001B – PP048. Welder is identified as 059450. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 001 located on Counter Weight CW002B – PP084. Welder is identified as 059450. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F – 1.

FCAW process welding of weld joint # 010 located on Counter Weight CW001B – PP048. Welder is identified as 059450. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

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BAY 2

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004405

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3004 – 001 – 004; 022 – Green Tag # 10532
2. FB3065 – 002 – 095; 096
3. FB3030 – 002 – 095; 096 – Green Tag # 10722
4. FB3029 – 001 – 095; 096 – Green Tag # 10720
5. FB3030 – 003 – 095; 096
6. FB3065 – 003 – 095; 096 – Green Tag # 10730
7. FB3065 – 001 – 095; 096 – Green Tag # 10728

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 045 located on Floor Beam FB3037 – 001. Welder is identified as 062438.

ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint # 028 located on Floor Beam FB3001 – 001. Welder is identified as 045209.

ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint # 010 located on Floor Beam FB3100 – 001. Welder is identified as 062438.

ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 045 located on Floor Beam FB3001 – 001. Welder is identified as 045209.

ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

BAY 3

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004403

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

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1. CB202E – 014 – 003

BAY 5

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004403

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB204 – 049 – 015; 021; 040; 046
2. FB204 – 051 – 015; 021; 040; 046
3. FB204 – 052 – 015; 021; 040; 046
4. FB205 – 049 – 005; 009; 016; 022
5. FB205 – 050 – 005; 009; 016; 022
6. FB205 – 051 – 005; 009; 016; 022
7. FB205 – 052 – 005; 009; 016; 022

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 006 located on Bike Path BK001 – 038. Welder is identified as 204342. ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

FCAW process welding of weld joint # 010 located on Traveler Rail 10TR3 – 008. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 011 located on Bike Path BK001 – 037. Welder is identified as 205390.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

FCAW process welding of weld joint # 005 located on Traveler Rail 10TR3 – 014. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 011 located on Bike Path BK001 – 040. Welder is identified as 217185.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

FCAW process welding of weld joint # 006 located on Bike Path BK001 – 041. Welder is identified as 215009.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
